

Date: Saturday, 11/19/2005 10:47:42 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	FLOAT SKIDTUBE ASSEMBLY
<b>Job Number</b> :	24799A		
<b>Estimate Number</b> :	10309		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206642541
<b>This Issue</b> :	11/19/2005	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3274 REV C
<b>First Issue</b> :	11	<b>Project Number</b> :	
<b>Previous Run</b> :	24798A	<b>Drawing Revision</b> :	C
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	12/20/2005
<b>Comment</b> :	Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001240	Extrusion Round 3" 206
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Pick:

Qty	Part Number	Description	Batch
1	D2600-1-240	3" OD Tube	B10427 DP 05-11-22

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

- 1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends DP 05-11-22
- 2-Drill #40 Aft cap pilot hole using DT8025 DP 05-11-22
- 3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 DP 05-11-22
- 4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 DP 05-11-24
- 5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end. DP 05-11-24
- 6-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274 Pmc 05-11-28
- 7-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274 Pmc 05-11-28
- 8-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube Pmc 05-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Saturday, 11/19/2005 10:47:42 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

A.M 05-11-24

①

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-01-03

①

5.0	D3282041	I-Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B24862 a.m 06-01-16

①

6.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

06-06-20

a.m 06-01-16

Start: 06-01-16

Time: 1:00

Finish: 06-01-23

Time: 2:30

a.m 06-01-23

①

①

(Adhere for 12 hours)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-01-22 ①

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

DP 06-1-23 ①

2-Cut Fwd end of tube to length as per Dwg D3274

DP 06-1-23 ①

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

BE 06-1-24 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for wearplates using D3274-1T2, then open to  $\varnothing 0.297$ " (without cutting fluid)

257

BE 06-01-24

5-Deburr

BE 06-01-24 (1)

6-C'sink cross bolt holes as per Dwg D3274

BE 06-01-24 (1)

9.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1

Fwd Cap

B21744

BE 06-01-26 (1)

10.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649

Crossbolt spacer

B24200

BE 06-01-26 (1)

11.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1

Crossbolt spacer

B24861

BE 06-01-26 (1)

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod M15855/M19100

BE 06-01-26 (1)

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod M15855

BE 06-01-26 (1)

3-Grind welds flush to Fwd cap on top surface only.

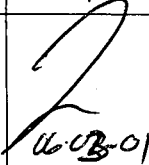
BE 06-02-01 (1)

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

fm 06-01-30 (1)

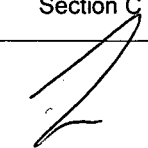
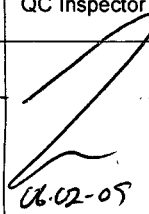
5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

fm 06-02-1 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-01	8.4	hole size is .257 AS per dwg. / change.	EE	06-03-01			 06-03-01

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-05	8.6	Wearplate holes <del>are</del> oversized due to improper C's ink method.		re-work wearplate holes AS per W/O 26005: NC2023. See Attached sheets.	BE 06-03-01	 06-03-01		 06-02-05

NOTE: Date & initial all entries

Date: Saturday, 11/19/2005 10:47:43 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

PD 06-02-02

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q 06-03-16

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description  
1 D3415-041 Nut Plate

Batch

324574

17.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 CCR264SS3-3 Rivet

Batch

M14651

18.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 CR3212-4-03 Rivet

Batch

M15918

DL 06/04/04

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D26483

Wearpad



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2648-3 Wearpad B24843

20.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-15 Wearshoe B21712

21.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-23 Wearshoe B22085

22.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe B24148

23.0

D32871

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3287-1 Wearshoe B21714

24.0

D34291

WEARPAD



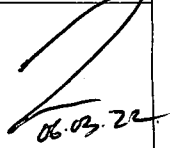
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B24417

DL 06/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.03.22	19	9x D2648-3 are req'd for skid. see DWG 03274 Adjust estimate.	E	06.03.22			 06.03.22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/04/10  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Saturday, 11/19/2005 10:47:43 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN960C10L	Inventory
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Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 AN960C10L Washer M18822 ✓

26.0	MS27039C108	SCREW
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Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 MS27039C1-08Screw M17460 ✓

27.0	NAS1330C3KB116	Insert
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Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1330C3KB116 Inserts M19014 ✓

28.0	NAS1515H3L	WASHER
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Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch

78 NAS1515H3L Washer M17450 ✓

DL 06/04/04

29.0	D34131	RING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B241222 ✓

FL 06 04 00/

30.0	AN4C5A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M18918 ✓

FL 06 04 00/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Saturday, 11/19/2005 10:47:43 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	AN960C416L	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C416L	Washer	m18822

FC

32.0	NAS1515H4L	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H4L	Washer	m19099

FC

33.0	D2646	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	1233705

FC

34.0	AN960C10L	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	m18822

FC

35.0	MS27039C108	SCREW
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS27039C1-08Screw		m19185

FC

36.0	NAS1515H3L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	m19185

FC 06 03 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24799A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. *FC*

A/RN/ALPS-3 *m17395*

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube. *and wear pads*

A/R Sikaflex-291 *m19597*

Sikaflex expire date: *06 18 06*

*Q. m 06-03-21*

*FC*

3-Install ring as per Dwg D3274

A/R Sikaflex-291 *m19597*

Sikaflex expire date: *06 18 06*

*FC*

*06 04 06*

4-Inspect for foreign objects as per QSI 024

*FC*

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 *m19597*

Sikaflex expire date: *06 18 06*

*FC*

*(1)*

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*m 06 04 06*

*(1)*

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/04/06*

Job Completion



*u ready.07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/03/17	37.2	- Put Sikaflex under D2648-3 : D3429-1 wear pads. - Add this step to I. P. P. Permanent Change				06/03/17	06/03/17	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 13 Date: 06/03/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 2/28/2006 10:20:01 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b>	: D206-642-541
<b>Job Number</b>	: 26005		
<b>Estimate Number</b>	: 10804		
<b>P.O. Number</b>	:	<b>Part Number</b>	: Z_CUSTOM
<b>This Issue</b>	: 2/28/2006	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: REWORK
<b>First Issue</b>	: 11	<b>Project Number</b>	:
<b>Previous Run</b>	: 00015	<b>Drawing Revision</b>	:
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	:	<b>Due Date</b>	: 3/7/2006
<b>Comment</b>	:	<b>Qty:</b>	4 Um: Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1



**Comment:** LANDING GEAR RESOURCE 1  
REWORK D206-642-541  
1 X B24801A  
1 X B24794A  
1 X B24799A  
1 X B24802A

**REFERENCE ONLY**

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1  
REWORK AS FOLLOWS:  
FILL WEARPLATE HOLES OVER .270 WITH WELD AS PER QSI042  
GRIND FLUSH  
DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .1875  
C'SINK WITH 3/16 C'SINK BIT (ENSURE NOT TO C'SINK TO DEEP)  
OPEN HOLES TO .257 AS PER DRWG D3274  
FINISH C'SINK WITH .257 C'SINK BIT (ENSURE NOT TO C'SINK PAST THE BOTTOM, ONLY CUT THE TOP) AND INSPECT C'SINK WITH A SAMPLE NAS1330C3KB116 INSERT TO ENSURE INSERTS WILL SIT FLUSH, AND HOLE IS NOT OVERSIZED  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP  
INSPECT LEVEL 5/9

Date: Tuesday, 2/28/2006 10:20:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-541

Job Number: 26005

Part Number: Z\_CUSTOM

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

RETURN TO ORIGINAL W/O TO NEXT STEPS

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Job Completion



REFERENCE ONLY

**Linda Lacelle**

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** Tuesday, February 14, 2006 3:48 PM  
**To:** Jason Murdoch  
**Cc:** Bill Beckett; Linda Lacelle  
**Subject:** Re: 206 floats

Jason,

In talking to Bill about this, I think that we should go ahead and plug any holes above 0.270 and then re-countersink the holes properly in order to salvage these tubes.

David

----- Original Message -----

**From:** Jason Murdoch  
**To:** [davids@dartaero.com](mailto:davids@dartaero.com)  
**Sent:** Tuesday, February 14, 2006 7:22 AM  
**Subject:** RE: 206 floats

REFERENCE ONLY

Have you had a chance to think about the floats yet?

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**Q.C.Inspector**

**From:** Jason Murdoch [mailto:[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)]  
**Sent:** February 9, 2006 11:30 AM  
**To:** [davids@dartaero.com](mailto:davids@dartaero.com)  
**Cc:** Linda lacelle ([llacelle@dartaero.com](mailto:llacelle@dartaero.com)); BILL BECKETT ([bbeckett@dartaero.com](mailto:bbeckett@dartaero.com))  
**Subject:** 206 floats

3 out of 6 tubes are ok. The 3 that are not so good have hole dims. That vary anywhere from .275-.293 ovally on average. The smallest of the oversized holes is .273 and the largest is .303. the thing is on the 3 tubes, it's like 97% of the holes are like this and even in the bent sections. I sent the other 3 to finishing but not to be painted until I get a solution to this problem, to ensure that they'll be ok for assembly. The holes do not exceed .270( MAX ON ONLY A COUPLE OF HOLES OUT OF THE 3 TUBES ) I did some tests with some inserts on a scrap piece of 206 mat' with different hole sizes and by putting a bolt in the insert and wiggling it around a little ( not to hard to bend anything ) and then by trying to turn the insert in the hole by gripping it with some vise grips :

.287 / the inserts come loose and turns in the hole

.276 / insert is a little tighter on the wobble, and turns slightly from side to side with more force than the .287 for sure

.273 / fit is even tighter.

What are your suggestions ?

I think that holes under .270 should be alright, considering the holes should be .257 as per dwg ( which mind you is to be up dated )

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**Q.C.Inspector**